

Work Order ID 81654

81654

Page 1

March-16-12 1:52:43 PM

Item ID: D3570-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 16/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3570	Rev E
-------	-------

100

0.00

100

FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3570

Dwg Rev: _____

Prog Rev: _____

GRAIN DIRECTION AS PER DWG

2-Deburr if necessary

6061 . 125

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

SCRAP

Scrap

B12-6-20

B12-6-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81654

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Page 2

March-16-12 1:52:43 PM

Item ID: D3570-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 16/03/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 30/03/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(412)			
130 *130* Small Fab Small Fab Small Fab	Small Fab Memo 1-Form as per Dwg D3570 Using DT8945 2-Cut excess material as per Dwg D3570. 3-Drill as per Dwg D3570 Using Dt8946	0.00 0.00				12			FF 12-07-10 Pto 7
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: *AK* Date: 13/10/03
 Resolution: _____ Disposition: _____ QA: N/C Closed: *AK* Date: 13/09/30

NCR: <u>13-3082</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/07/11	#130	Found at inspection Qty x 12 Parts had have the 0.325" hole drilled at center + Bent to right hole should be 0.336 ± 0.020 From Part center to edge of hole P.C.	<i>S</i> 027042 12/07/11	Must part meet 0.3 Scraper + Destroy no Rephe Qty x 12	<i>AK</i> 13-09-24	<i>S</i> 13/09/25	<i>S</i> 027042 12/07/11	<i>S</i> 12/07/11
				<i>13/09/24</i> <i>5.27</i>				

NOTE: Date & initial all entries

81654

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME:

QC3- Inspect Part Finish

0,00

170

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Work Order ID 81654***81654***

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

U 130925

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-16-12 1:52:47 PM

Page 1

Work Order ID: 81654

81654

Parent Item: D3570-2

D3570-2

Parent Item Name: Bracket

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-03.26 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased			No	100	sf	92.5800	0.07	0.736842	(

M6061T6S 125

**

B12-6-24

6061-T6.125 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	92.58	
113608	46.69	
118217	0.09	
119513	10.8	
120218	35	

121 473

(12)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 81654
Description: Bracket		Part Number: D3570-2
Inspection Dwg: D3570	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.209	+0.005/-0.001	.210	L		V (B2)	
0.359	+/-0.010	.358	L		V	
0.557	+/-0.010	.557	L		V	
1.943	+/-0.010	1.939	L		V	
2.141	+/-0.010	2.140	L		V	
2.50	+/-0.030	2.50	L		V	
4.75	+/-0.030	4.755	L		V	
0.311	+/-0.010	.311	L		V	
0.533	+/-0.010	.533	L		V	
1.717	+/-0.010	1.715	L		V	
1.939	+/-0.010	1.937	L		V	
2.25	+/-0.030	2.258	L		V	
0.125	+/-0.010	.125	L		V	

Measured by: B
Date: 12-6-26

Audited by: S
Date: 12/6/27

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.10.16	New Issue	KJ	

Dart Aerospace Ltd

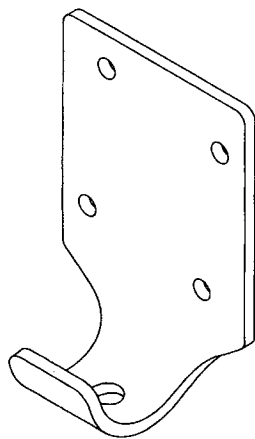
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

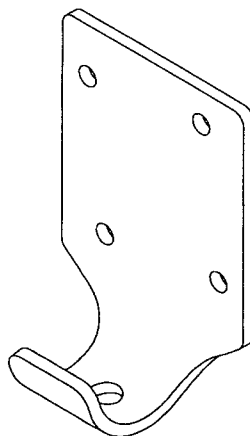
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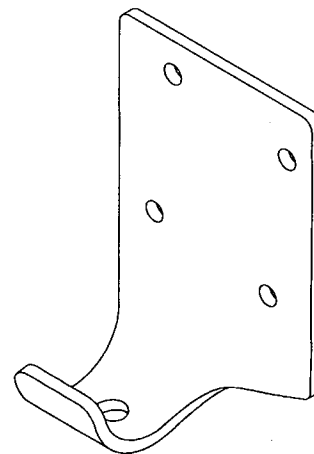
NOTE: Date & initial all entries



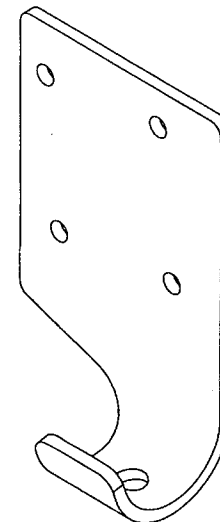
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

RELEASED
09/04/22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 811654 MLJ

12/03/16

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.05.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	B	D3570	SHEET 1 OF 5
APPROVED	12	TITLE	SCALE
DE APPR.	11	BRACKET	NTS
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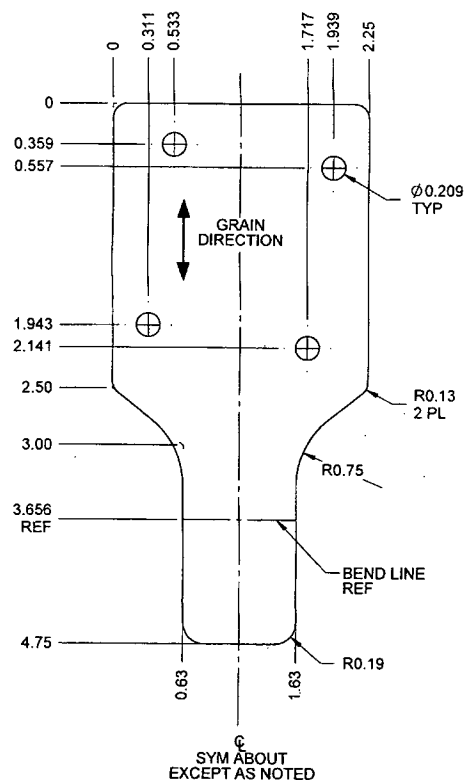
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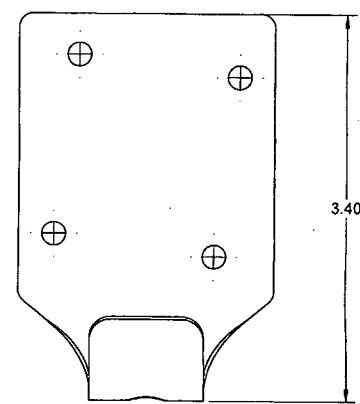
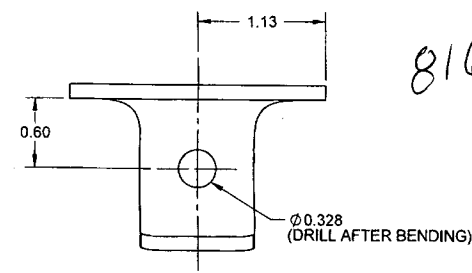
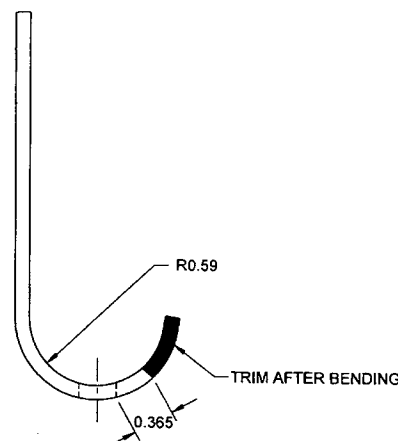
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3570-1F FLAT PATTERN



D3570-1 BRACKET
(MAKE FOM D3570-1F)

RELEASED
29/6/23 NH

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3570	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE BRACKET	SCALE NTS
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DATE	09.04.22		

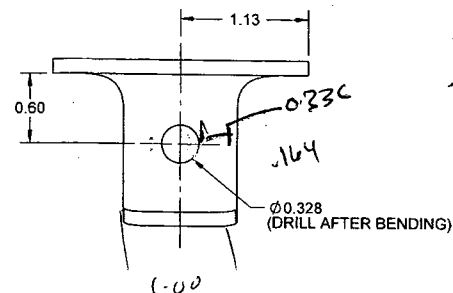
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

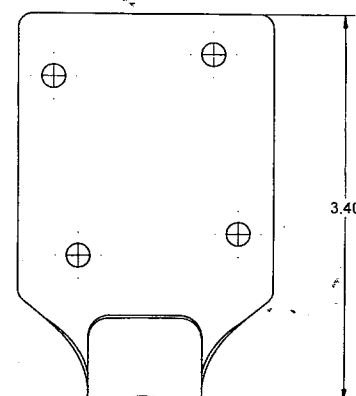
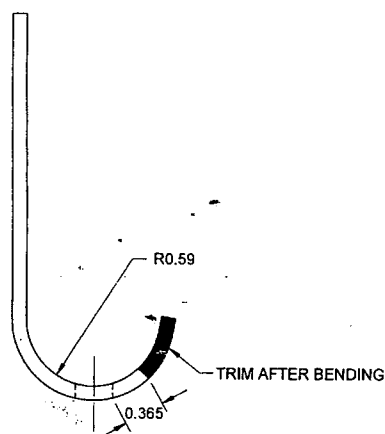
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



81654



D3570-2 BRACKET
(MAKE FROM D3570-1F)

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09/04/22

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CHECKED	J	DRAWING NO.	REV. E
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W/O:		WORK ORDER CHANGES					
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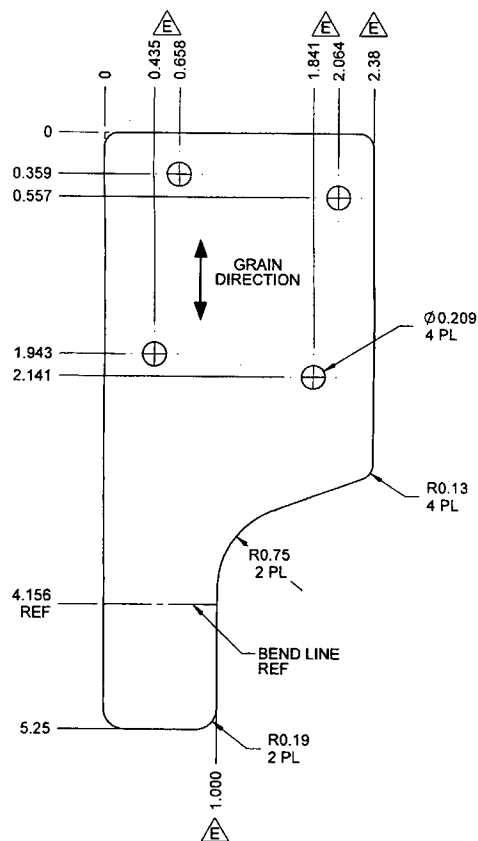
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

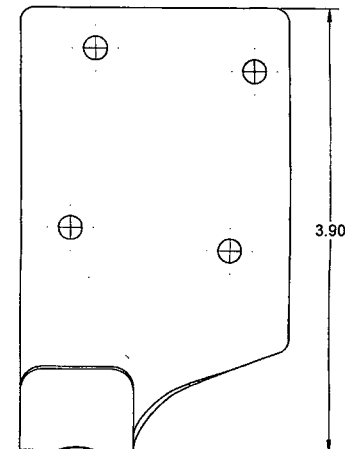
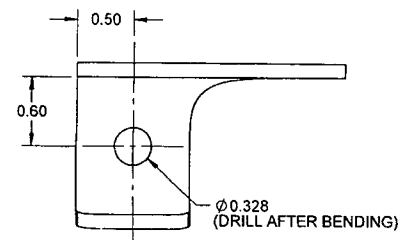
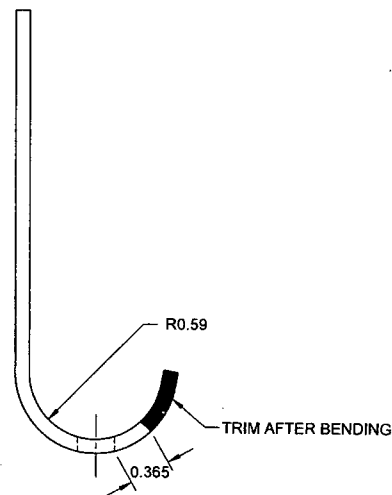
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81654



D3570-3F FLAT PATTERN



D3570-3 BRACKET
(MAKE FROM D3570-3F)

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09/24/23

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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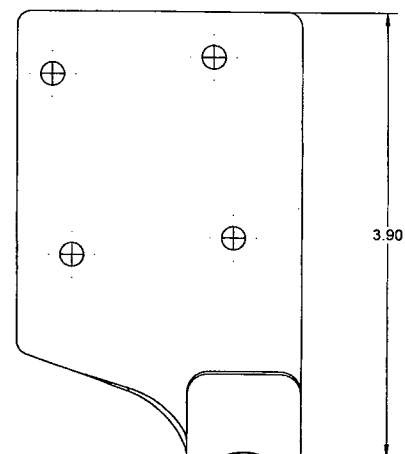
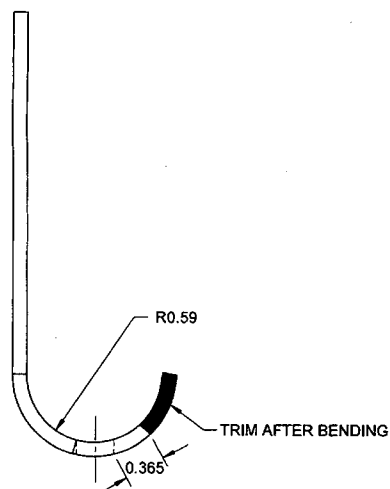
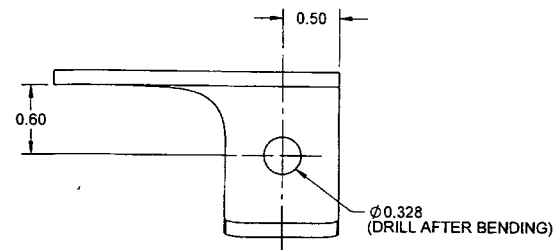
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(MAKE FROM D3570-3F)

RELEASED

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	E	D3570	SHEET 5 OF 5
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